

## SOURCE

1 U.C.COMPONENTS, INC.  
2330 OLD MIDDLEFIELD WAY  
SUITE 16  
MOUNTAIN VIEW, CA 94043-2408  
PHONE: (415) 964-3827

### NOTES:

1. THIS IS A UHV ASSEMBLY, KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR UHV PACKING WITH ALUMINUM FOIL.

2. DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10<sup>-10</sup> STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

ALCATEL ASM-110TCL  
VARIAN NCR 925 OR 936  
VEECO MS-9, MS-90 OR MS-18  
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

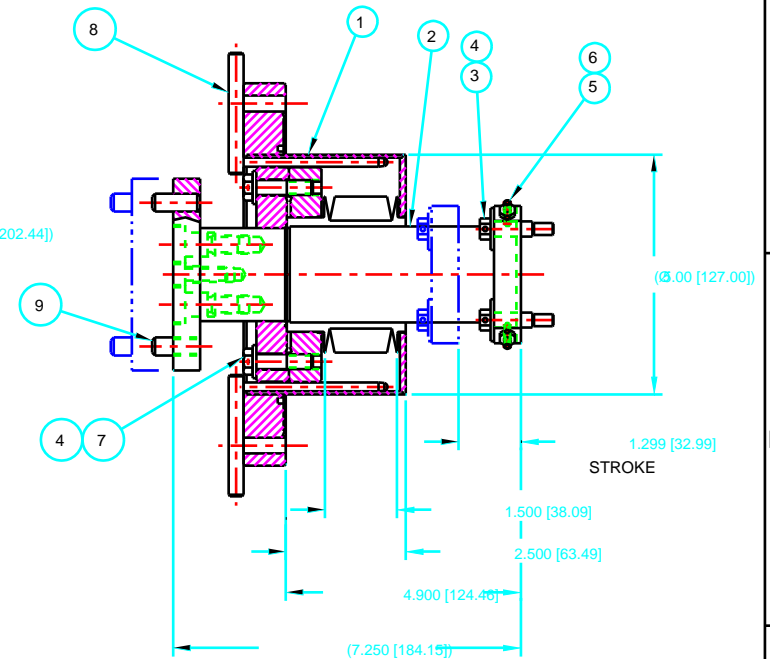
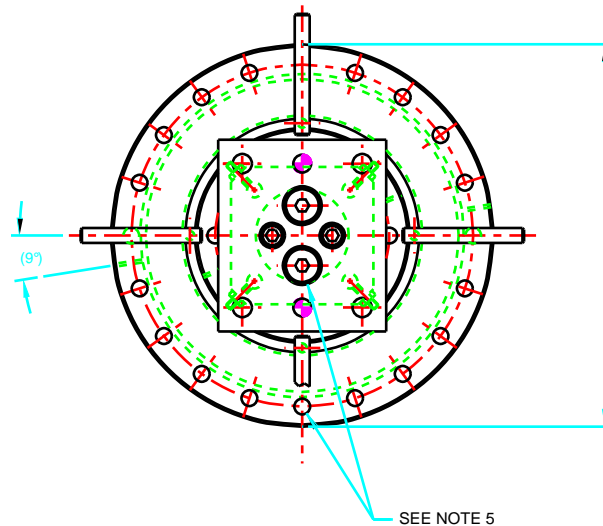
3. THE OPERATING STROKE IS 1.299 IN. (33mm)

4. USE L-PINS TO LOCATE Ø-1/2" FLANGE IN THE CENTER OF Ø" FLANGE WHEN INSTALLING ITEM 2 AND WHENEVER HANDLING THE ABOVE ASSEMBLY TO PREVENT AXIAL MOVEMENT.

5. FLANGE HOLE HAS TO LINE UP WITH SHOULDER SCREW HOLES UPON ASSEMBLY WITH ITEM 2.

6. ALL DIMENSIONS WITH ARE MILLIMETERS

7. ITEM 8; "L" PIN, IS FOR HANDLING & INSTALLATION MUST BE REMOVED AT ASSEMBLY AFTER ALIGNMENT - SEE INSTALLATION PROCEDURE - S3-200000-00-4 STEP 4



9		Ø8/8" x 1" LG. DOWEL PIN	SST	2
8	ADB-37015	Ø8/16 L-PIN AMERICA DRILL BUSHING CO. OR EQUIV.	HT-STEEL	4
7		5/16-18 UNC-2B SOC HD SCR x 7/8 LG.	SST	8
6		#6 - 32 UNC 2B NUT	SST	4
5		#6 - 32 X 3/8" LG. VENTED SET SCREW	SST-SILVER PLATED	4
4		Ø34 I.D. X .065 THK. PLAIN WASHER	SST	12
3	S3-230002-00	S3 MODIFIED SHOULDER SCREW	SST-SILVER PLATED	4
2	S3-230000-00-2	SEE SHEET 2 OF 2		1
1	P4105090104-810204-01	A4 BELLOWS WELDMENT		1

ITEM	DWG/PART NUMBER	NO. IN QUANTITY	DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST					
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES					
TOLERANCES					
FRACTIONS DECIMALS ANGLES					
1/16 0.0625 0° 0' 0"					
1/32 0.03125 0° 0' 0"					
1/64 0.015625 0° 0' 0"					
SURFACE FINISH 125					
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.					
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ASST. DATA					
REVISIONS & TOLERANCES IN ACCORDANCE WITH LATEST ASST. DATA					
BY CHG DATE					
NO NET SCALE DRAWING					
SEE PARTS LIST					
SCALE HALF SIZE					
SHEET 12 C					
DRAWING NUMBER S3-230000-00-1					